Work Order ID 105781

August-19-13 11:23:46 AM

105781

Item ID: D2012-106 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Arm

Start Date: 8/19/13 **Start Qty:** 6.00 *6*

Required Date: 9/03/13 **Req'd Qty:** 6.00 *6*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** MLS **Date:** 13-08-19 **Tooling:** _____ **Date:** _____ **Run Start** *NR1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2012-106	A								
100		0.00							
100	NC BRAKE					6	SAD	13-10-29	
Brake NC	**Memo**	0.00							
Brake NC	Punch to length as per Dwg D2012-106 & template D2012-106T1								
110		0.00							
110	Small Fab					6	SAD	13-10-29	
Small Fab	**Memo**	0.00							
Small Fab	1-Deburr								
120	QC5- Inspect part completeness to step on W/O	0.00				6			
120									
QC	**Memo**	0.00							
Quality Control									

DAS 27 9-89 13.10.29

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Crosstube ☐
- Water Jet ☐
- Engineering ☐
- Machining ☐
- Small Fab ☐
- Prod. Eng. Coor. ☐
- Quality ☐
- Thermoforming ☐
- Finishing ☐
- Rec/Store/Packaging ☐
- Other ☐
- Large Fab ☐
- Composite ☐
- Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data										
Equip/Tooling										
Operator										
Material										
Setup										
Other										
Process										
Supplier										
Training										
Unapproved										

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

Item ID: D2012-106 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Arm
Start Date: 8/19/13 **Start Qty:** 6.00 *6*
Required Date: 9/03/13 **Req'd Qty:** 6.00 *6*
Reference:
Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	Black Sandtex(Ref:4.3,5.7) per QSI005 4.3 M 117338	0.00				6	0	13-10-29	DAS 34 9-89
	Memo START TIME: 2:00 OVEN TEMPERATURE: 500° FINISH TIME: 2:30	0.00							
140 *140* QC Quality Control	QC3- Inspect Part Finish	0.00 DAS 27 9-89				6			
	Memo B.10 30	0.00							
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: ST227	0.00				6X	DAS 28 9-89	13-10-30	
	Memo	0.00							

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

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- Scrap ☐
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- Work Order Update ☐

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- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

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Item ID: D2012-106 **Accept** *N900040100* **Setup Start** *NS1*
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Item Name: Arm

Start Date: 8/19/13 **Start Qty:** 6.00 *6*
Required Date: 9/03/13 **Req'd Qty:** 6.00 *6*
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00					13/10/31		
160									
QC	**Memo**	0.00							
Quality Control									

MF
13-10-30

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

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- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

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- Thermoforming ☐
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- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

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- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
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- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
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- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

Picklist Print

August-19-13 11:23:49 AM

Work Order ID: 105781 *105781*

Parent Item: D2012-106 *D2012-106*

Parent Item Name: Arm

Start Date: 8/19/13 **Required Date:** 9/03/13

Start Qty: 6.00 **Required Qty:** 6.00

Comments: IPP revA 11.07.12 new issue EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.035		Purchased	No			100	f	485.0001	2.651	16.74316			
M304TR0.500W.035									**	SAD		13-10-29	

304 RD Tube .500 x .035W

Location	Loc Qty	Loc Code	
MAT017	485.00013		
118702	0.00003		
123303	138.9645		
125513	346.0356	M26922	16.7432

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

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Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

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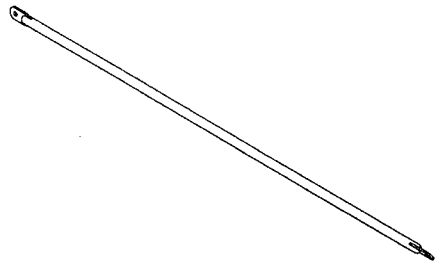
General

- ☐ Bend
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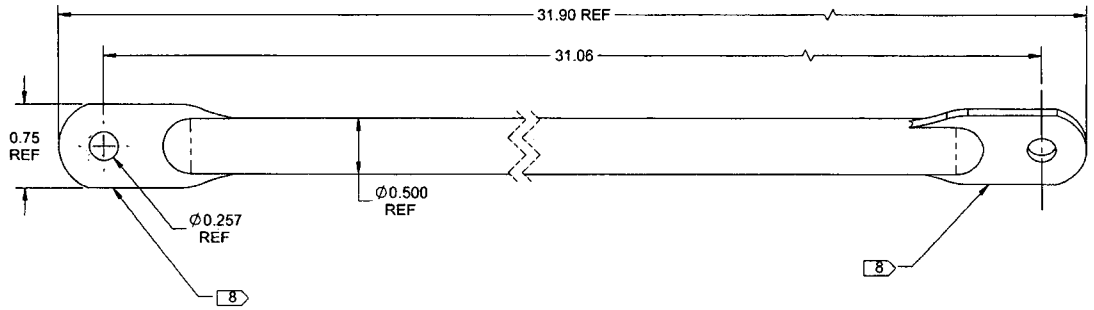
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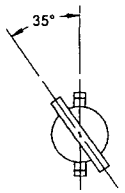
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105781 MLJ
13-08-19





D2012-106 ARM

RELEASED
2011-07-12

NOTES:
1) MATERIAL: AISI 304/316 SS TUBE Ø0.500 X 0.035 WALL PER ASTM A213/A269 OR ASME A213 (REF DART SPEC. M304TR0500W.035)
2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION:IDENTIFY WITH DART P/N "D2012-106" AND B/N "BXXXXX" PER DART QSI 044 6.1 USING REMOVABLE TAG
7) WEIGHT: 0.47 LBS (APPROX)
8) PUNCH BOTH ENDS PER SPEC CONTROL DWG D2727
9) NOTE THIS IS THE LH INSTALLATION VERSION OF D2012-105

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	AJS	11.07.11

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	AJS	
CHECKED		DRAWING NO. D2012-106 REV. A
MFG. APPR.		SHEET 1 OF 1
APPROVED		TITLE ARM
DE APPR.		SCALE NTS
DATE	11.07.11	

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DART AEROSPACE LTD

Description:	Arm (31.06)	**Work Order:**	105787
Inspection Drawing:	2012-106	Rev: E	Part Number: DA012-106

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
31.9	+/-0.100	31.937	✓		M-T	SAD-1
31.06	+/-0.030	31.09	✓		M-T	SAD-1
0.257	+0.006 +0.001	0.257	✓		Vern	Sfab-08
0.75	+/-0.030	0.750	✓		Vern	SFab-08
35°	+/- ½	35°	✓		Angle bevel	SFab-05

Measured by:	Checked By:	QC inspector DAS 27 9-89	Engineering Approval (*if necessary*):
SAD	SD	R 10 09	
Date 13/10/29	Date 13/10/29	Date	Date